

Work Order ID 83498

83498

Page 1

Thursday, April 19, 2012 10:22:42 AM

Item ID: D2010-103 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mirror Arm, 500
 Start Date: 4/19/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 4/27/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: *D* Date: *12-04-19* Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2010	Rev D								
100	NC BRAKE	0.00							
100									
Brake NC	Memo	0.00							
Brake NC	Punch per Dwg. D2010-103-T1 and Spec Control Dwg D2727 Identify as D2010-103								
110	Small Fab	0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1- Bend as per Dwg D2010 using bending Jig D2010-103T2 2- Deburr ends								
120	Small Fab	0.00							
120									
Small Fab	Memo	0.00							
Small Fab	1-flare before installling plug as per dwg D2010 2-Install D2057 plug as per Dwg D2010								

FF
12-05-29
6
FF
12-05-29
6
FF
12-05-30
6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2010-103

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mirror Arm, 500

Start Date: 4/19/2012 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 4/27/2012 **Req'd Qty:** 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

140

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

140

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE: 200

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

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Work Order ID 83498***83498***

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>220</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/6/4
MCJ 12/06/01

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 19, 2012 10:22:46 AM

Page 1

Work Order ID: 83498

83498

Parent Item: D2010-103

D2010-103

Parent Item Name: Mirror Arm, 500

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: F02.08.21Re-format; Added D2057 KJ/RF
IPP Rev:G 08-05-27 as per ECN1195P DD verified by:EC
IPP Rev:H 08-06-20 rev.D as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.049

Purchased

No

100

f

265.6762

1.5

9.473684

M304TR0 500W 049

304 RD Tube .500 x .049W

**

(6) FF 12-05-29

Location

Loc Qty

Loc Code

MAT017

265.676218

111814

2.23

115010

109.254058

117598

3.97

119087

7.359

120633

142.86316

9.473684

D2057

Manufactured

No

110

Each

28.0000

1

6

D2057

Plug

**

(6) FF 12-05-29

Location

Loc Qty

Loc Code

GA

28

71888

8

75070

20

3

3

W/O:		WORK ORDER CHANGES					
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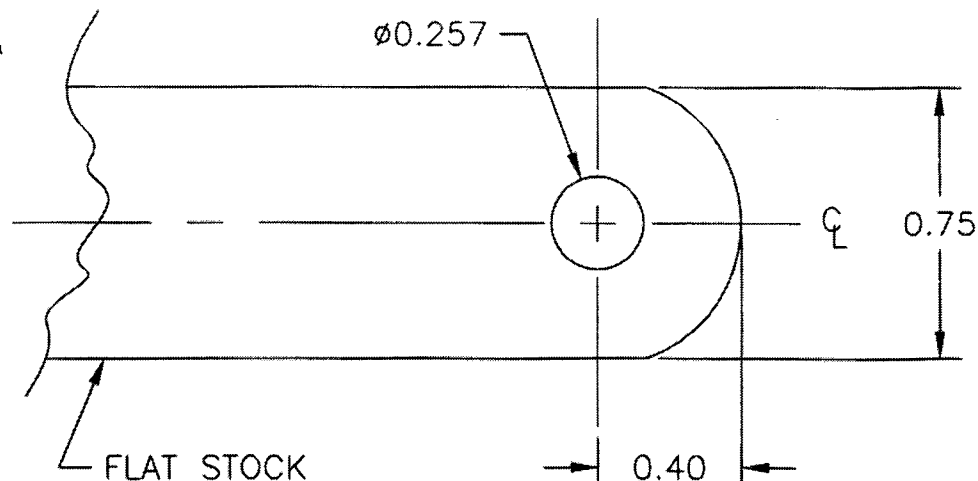
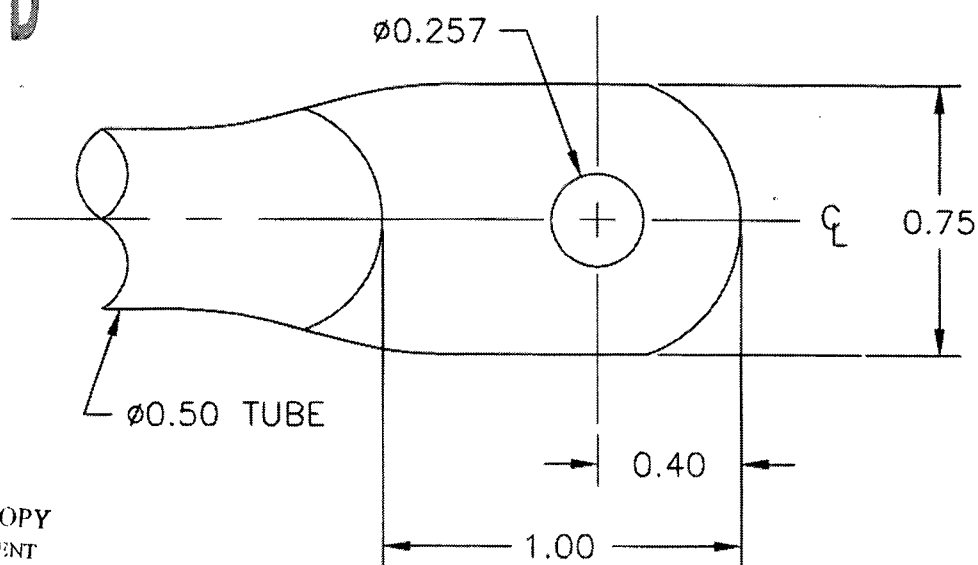
DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>DM</i>	APPROVED <i>CA</i>	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	<i>#ip</i> 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 *KE*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *83498*

112-07-19



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



W/O:		WORK ORDER CHANGES					
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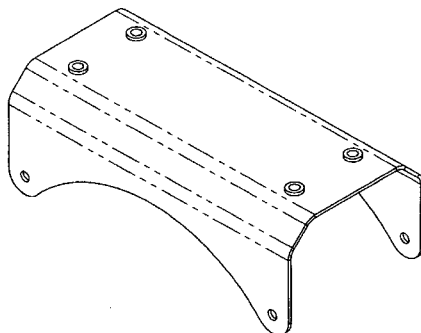
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

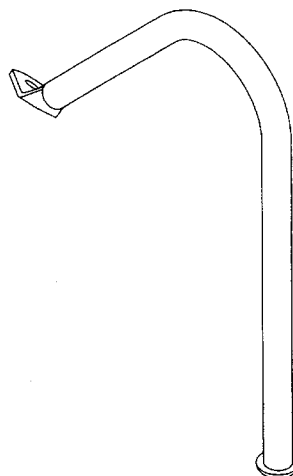
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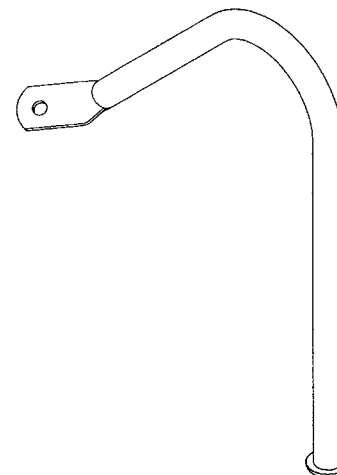
83498



D2010-101 MIRROR BRACKET



D2010-103 ARM



D2010-104 ARM

RELEASED
08.06.10

D	REDRAWN IN SOLIDWORKS; ADD D2010-1F FLAT PATTERN FOR D2010-101 (ZN B7-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN B1-3, B1-4); REASON: TUBING CRACKING DURING SERVICE	PH	08.06.10
C	1.93 WAS 2.00; 0.50 WAS 0.62	KE	97.10.31
B	7.90 WAS 10.90	JB	92.03.17
A	NEW ISSUE	JB	90.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	JB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JB	DRAWING NO.	REV. D
MFG. APPR.	JB	D2010	SHEET 1 OF 4
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	MIRROR BRACKET	NTS
DATE	08.06.10	COPYRIGHT © 1990 BY DART AEROSPACE LTD	
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WORK ORDER CHANGES

PROCEDURE CHANGE

By

Date

Qty

Approval
Chief Eng /
Prod MgrApproval
QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

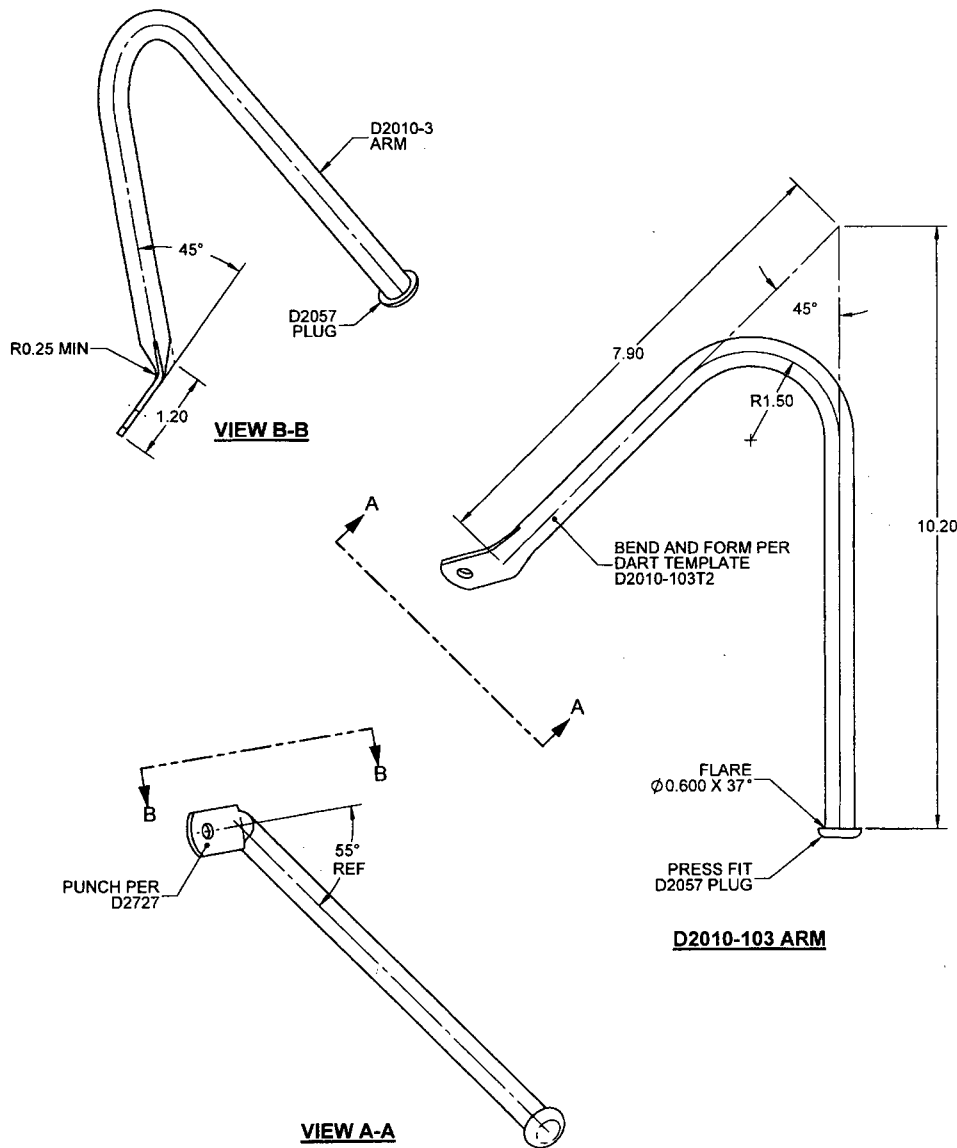
WORK ORDER NON-CONFORMANCE (NCR)

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8 7 6 5 4 3 2 1

QTY -103	P/N	DESCRIPTION
X	D2010-103	ARM
1	D2010-3	ARM
1	D2057	PLUG



83498

RELEASED
08 06 1977

- NOTES:
- 1) MATERIAL: D2010-3: AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049) Δ
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-103" USING WHITE FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	JB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JB	DRAWING NO.	REV. D
MFG. APPR.	JB	D2010	SHEET 3 OF 4
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	MIRROR BRACKET	NTS
DATE	08.06.10	COPYRIGHT © 1990 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

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